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(54) **HARSH ENVIRONMENT CONNECTOR  
INCLUDING END CAP AND LATCHING  
FEATURES AND ASSOCIATED METHODS**

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**H01R 13/627** (2006.01)

(52) **U.S. Cl.** ..... **439/353**

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439/138, 201, 353, 358, 357, 204  
See application file for complete search history.

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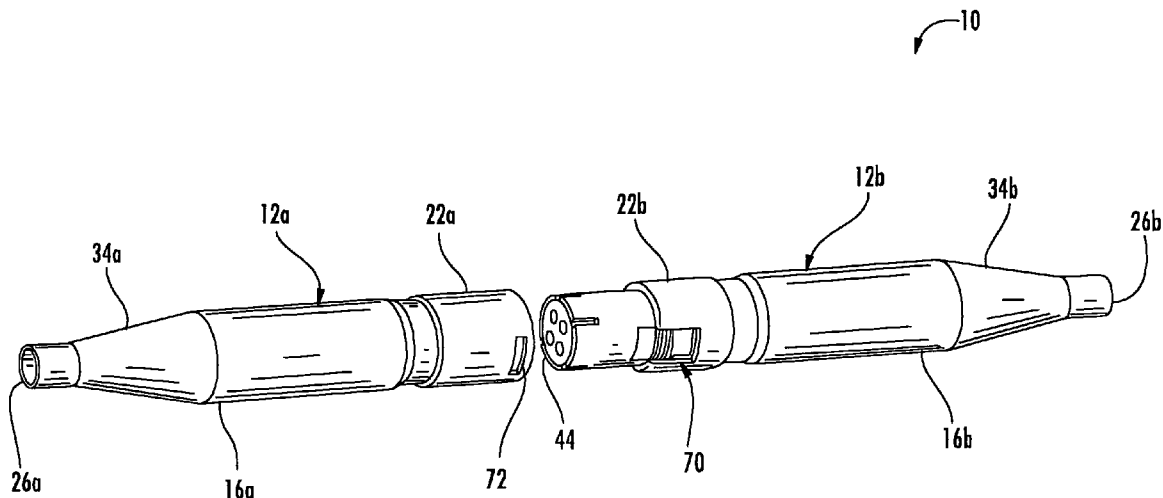
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(57) **ABSTRACT**

A connector, such as for harsh environments, may include first and second connector portions being movable between unmated and mated positions. The first connector portion may include a first base, at least one male contact carried by the first base and extending outwardly therefrom, and a first shell carried by the first base and surrounding the at least one male contact. The second connector portion may include a second base, at least one female contact carried by the second base and extending outwardly therefrom, and a bladder carried by the second base and surrounding the at least one female contact. The second connector portion may further include an end cap having at least one passageway therein for retaining and aligning end portions of the bladder opposite the second base, and a second shell carried by the second base and surrounding the bladder and the end cap. The end cap and adjacent portions of the second shell may include respective mating portions to provide a snap fit engagement therebetween. The end cap may include an integrally formed monolithic body. A manual release latch and corresponding latch opening may be provided in the connector shells.

**36 Claims, 16 Drawing Sheets**



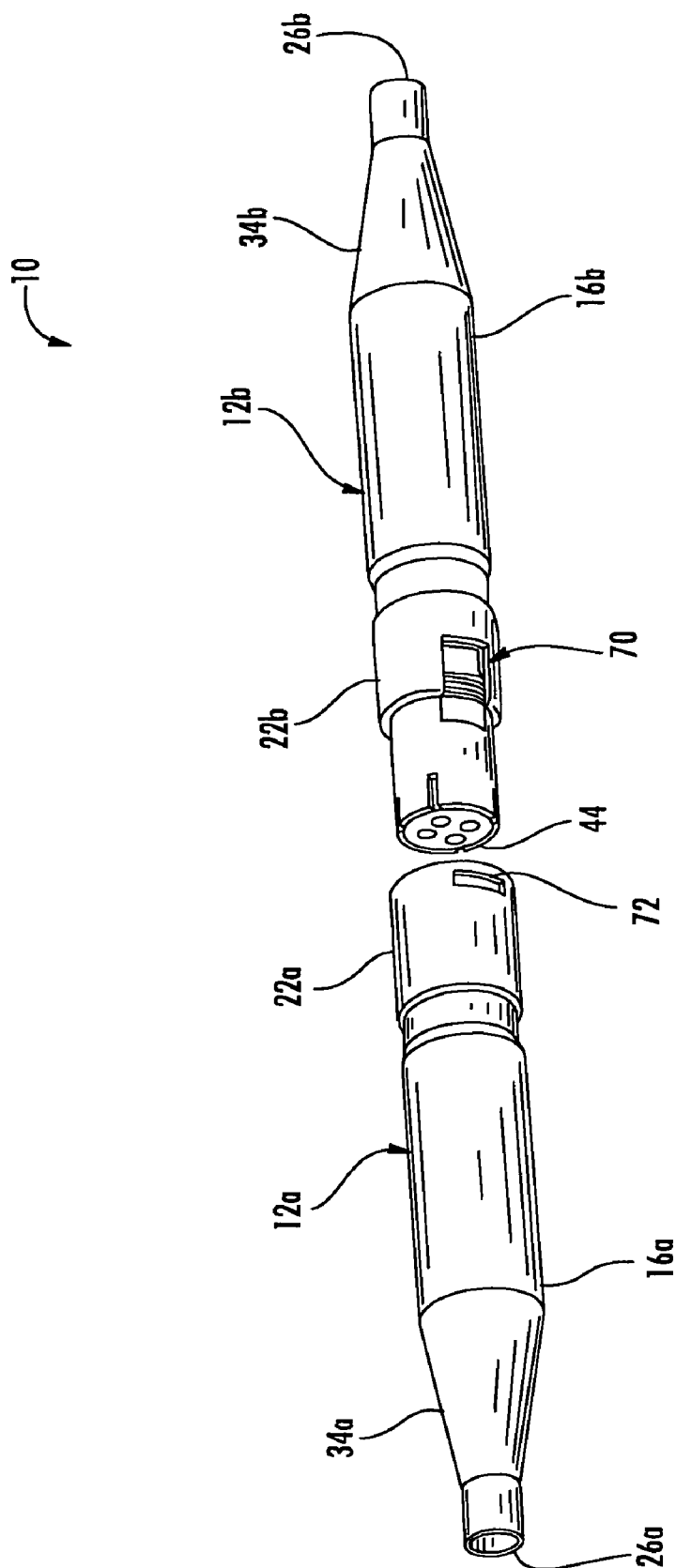


FIG. 1

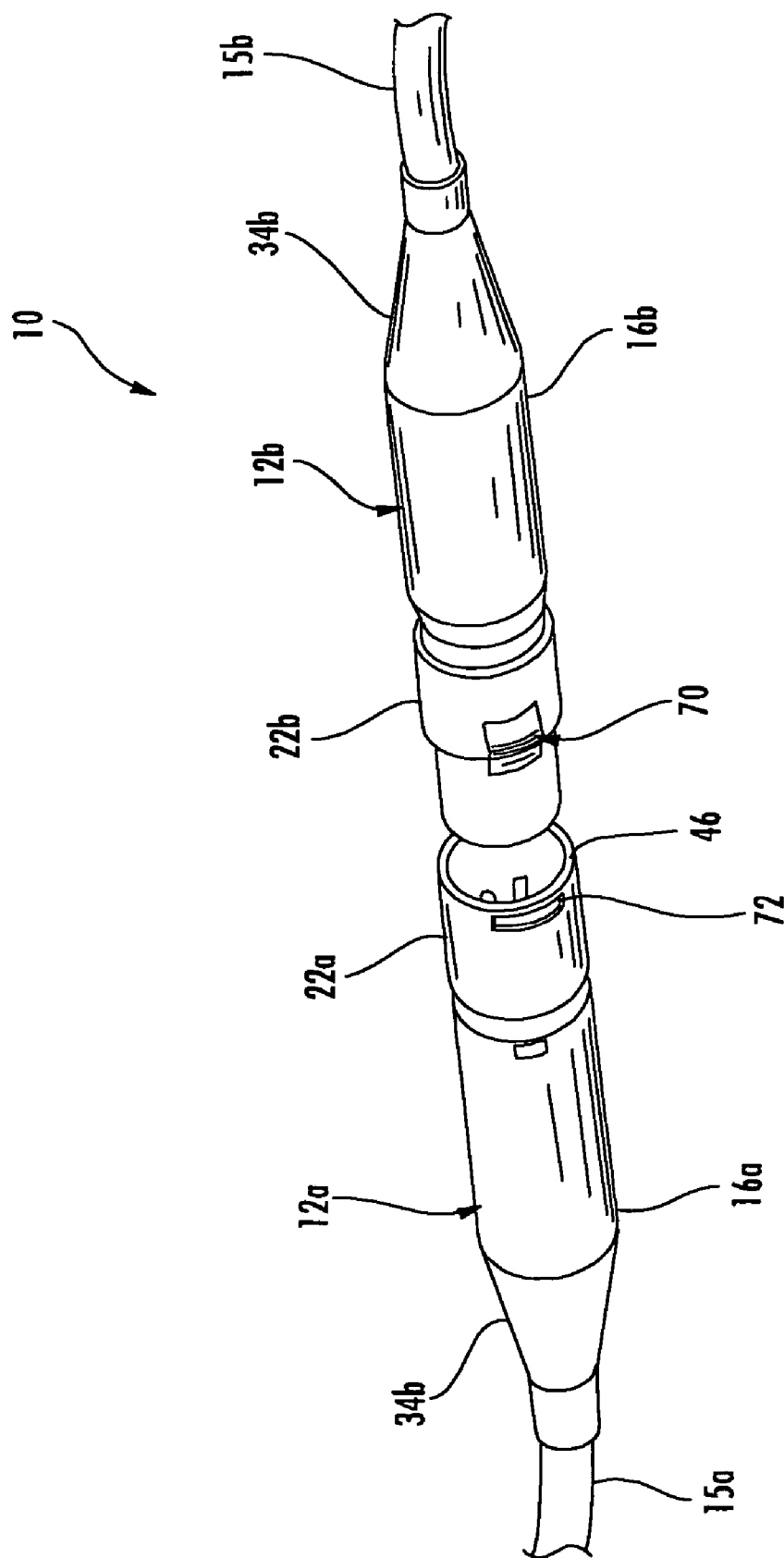


FIG. 2

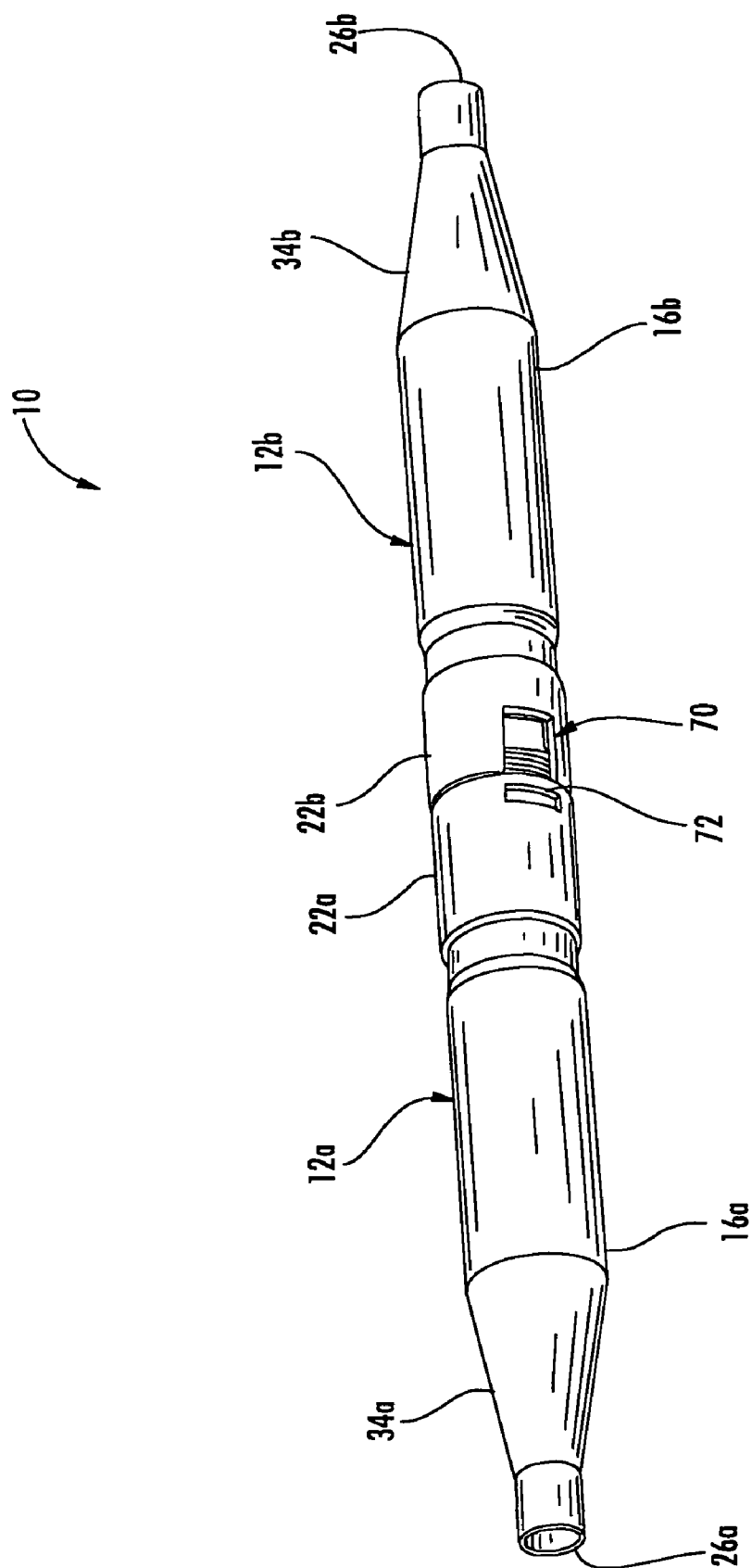


FIG. 3

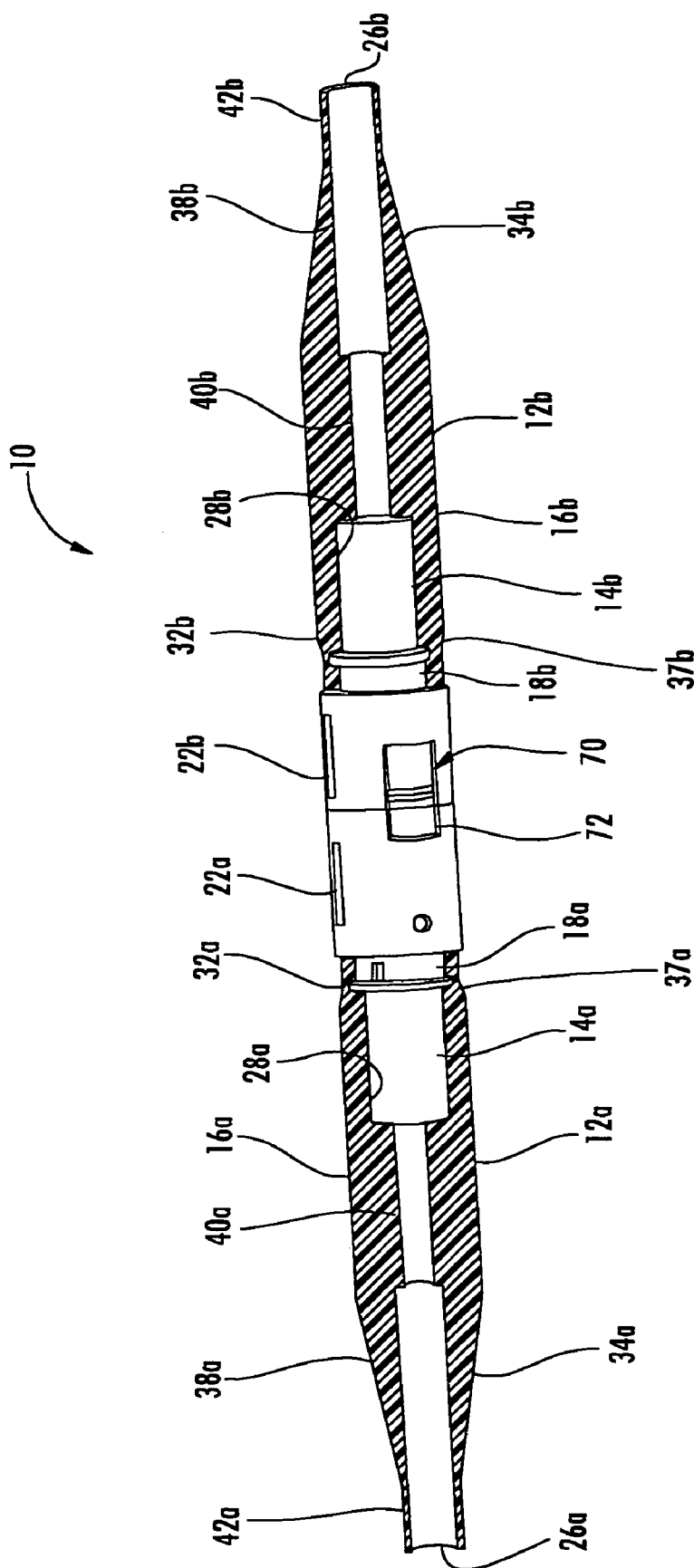


FIG. 4

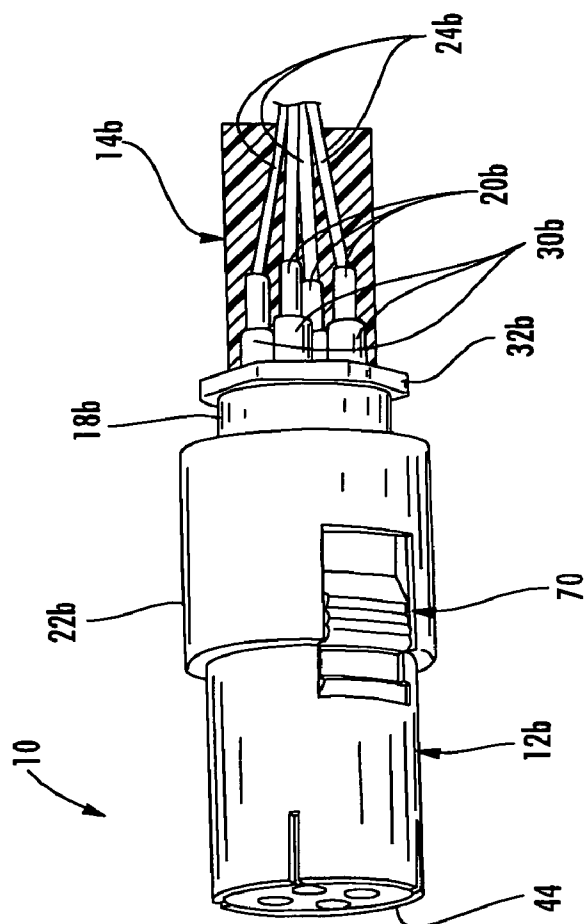


FIG. 5

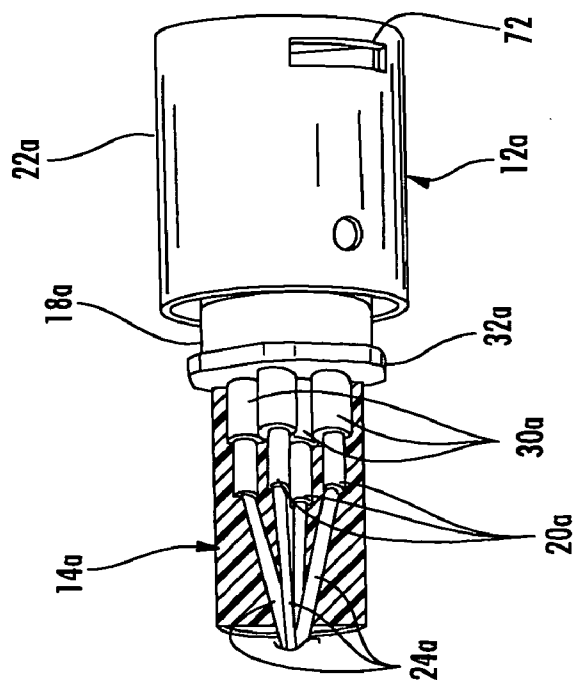
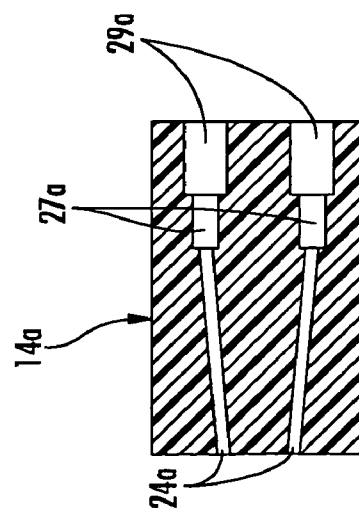
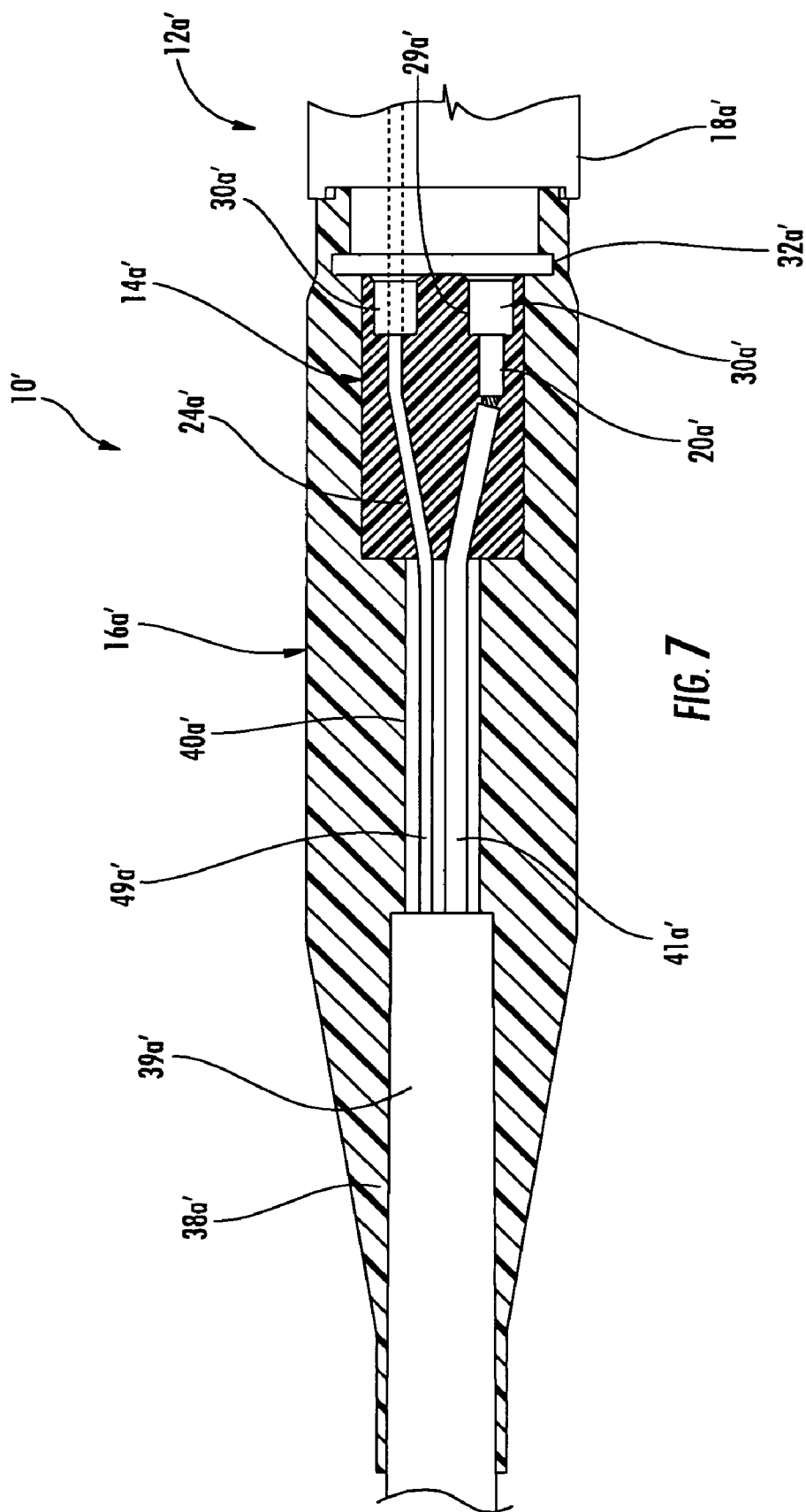
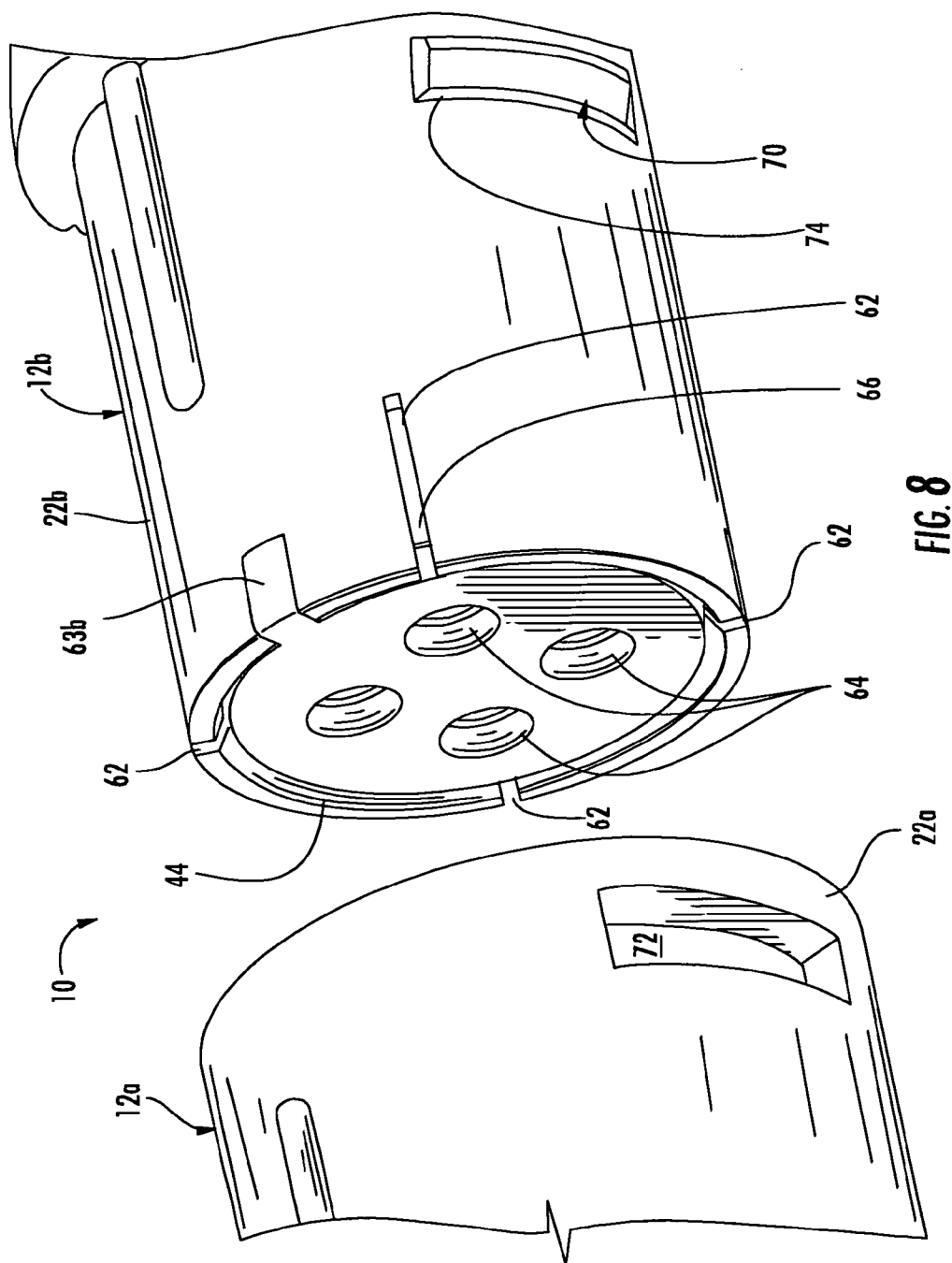


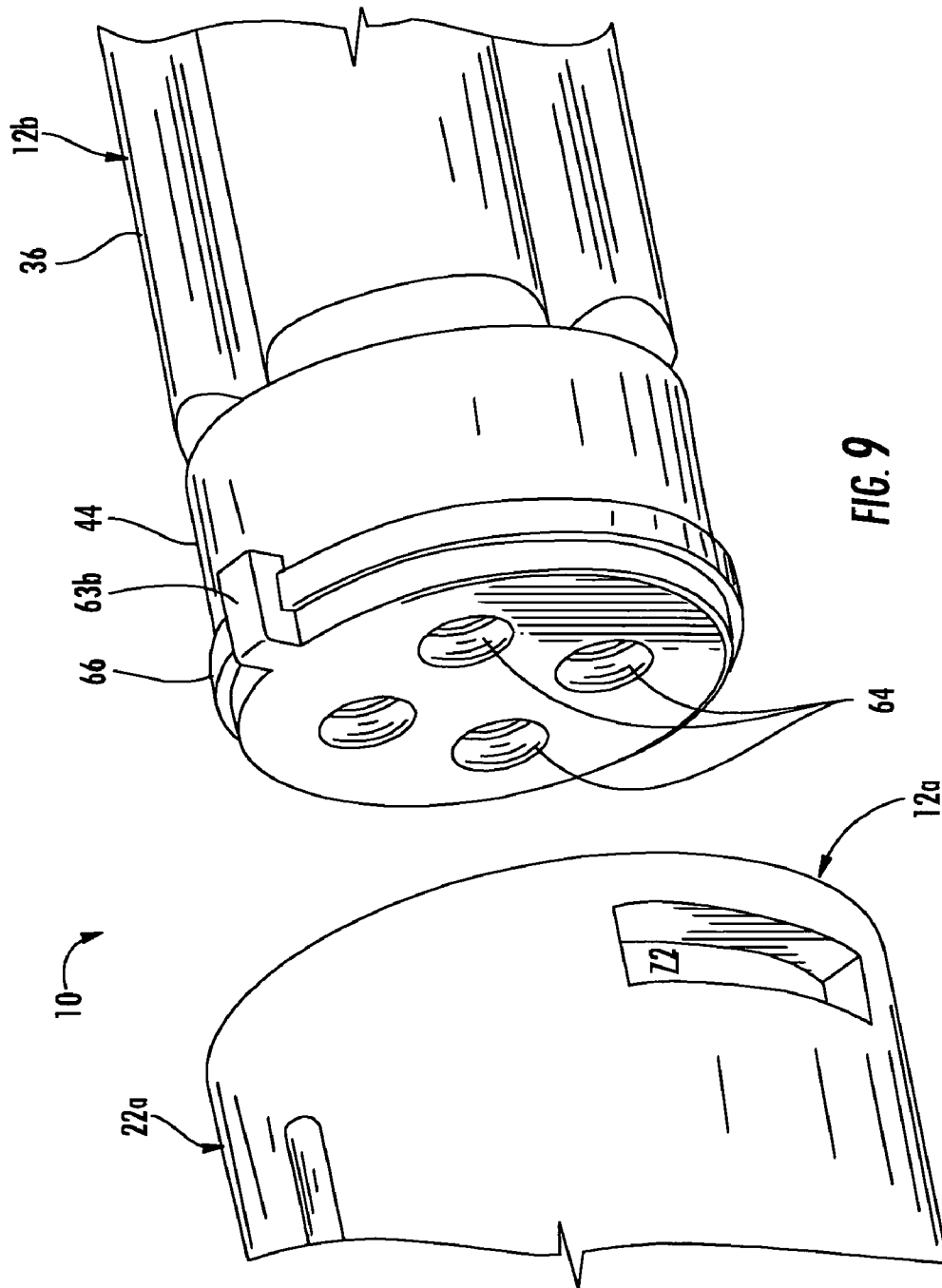
FIG. 6

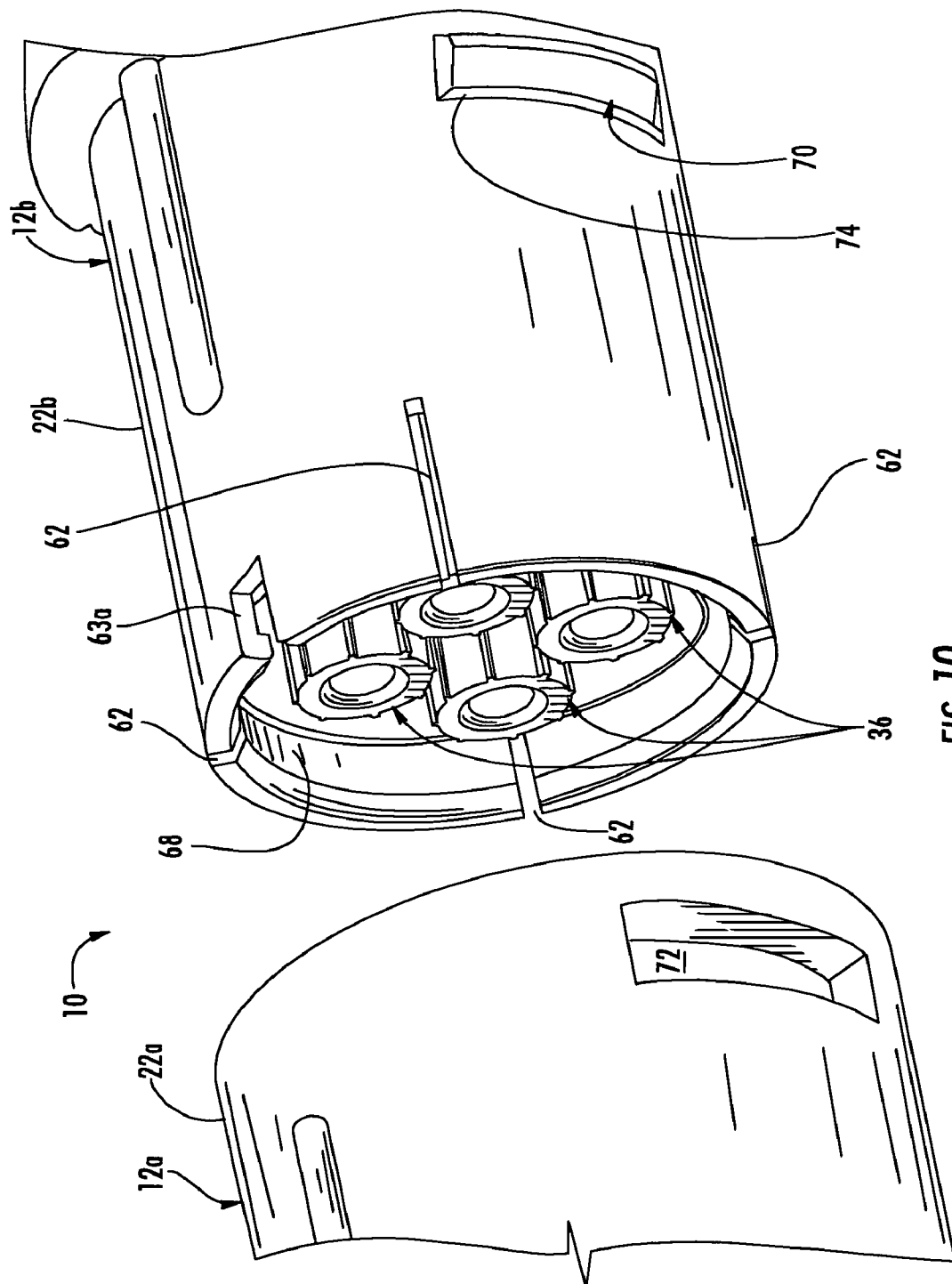












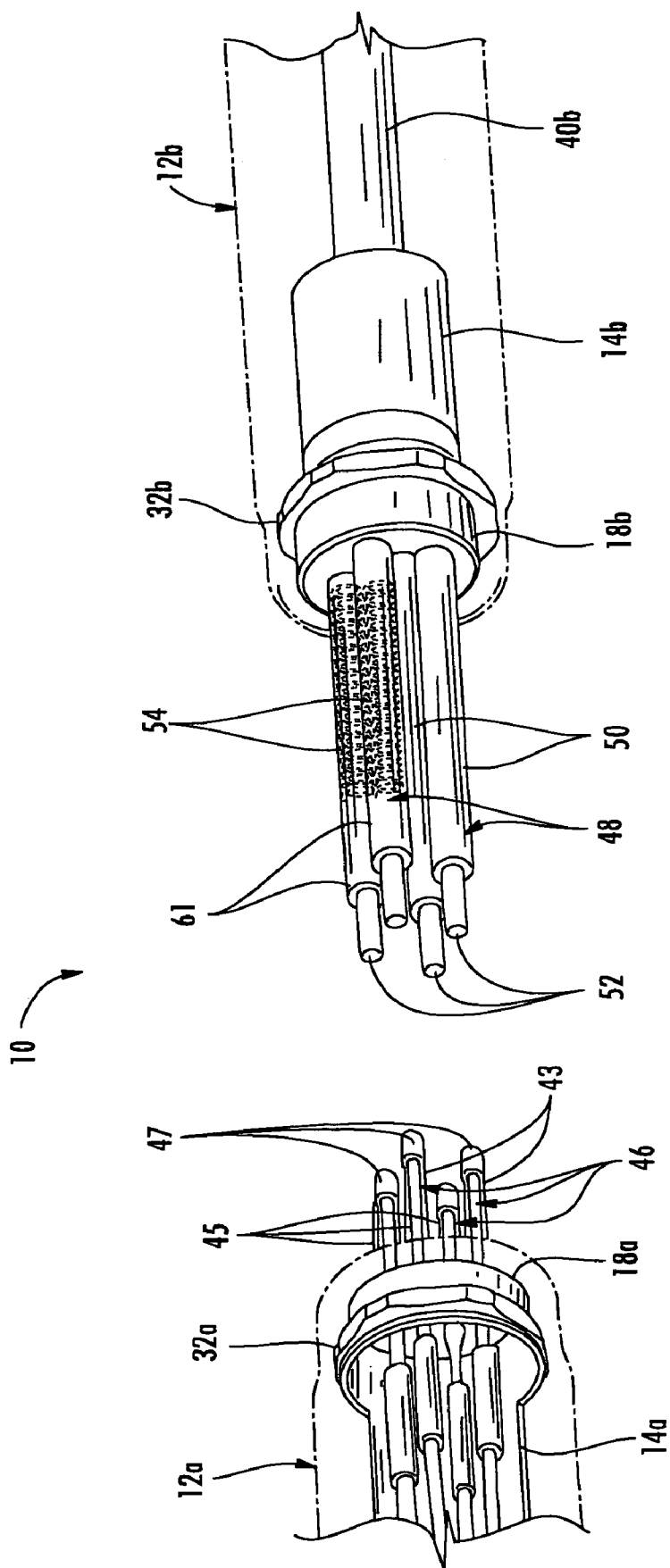
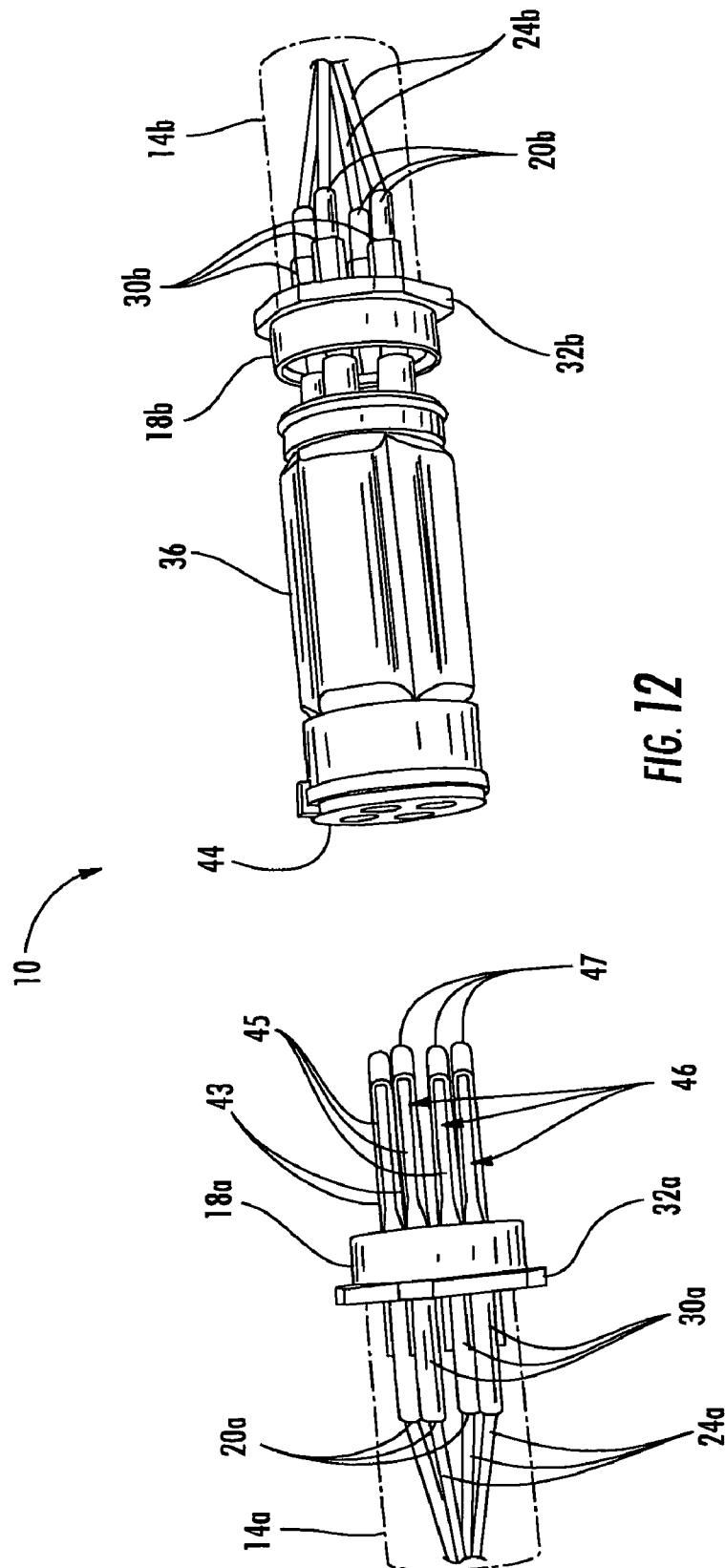


FIG. 17



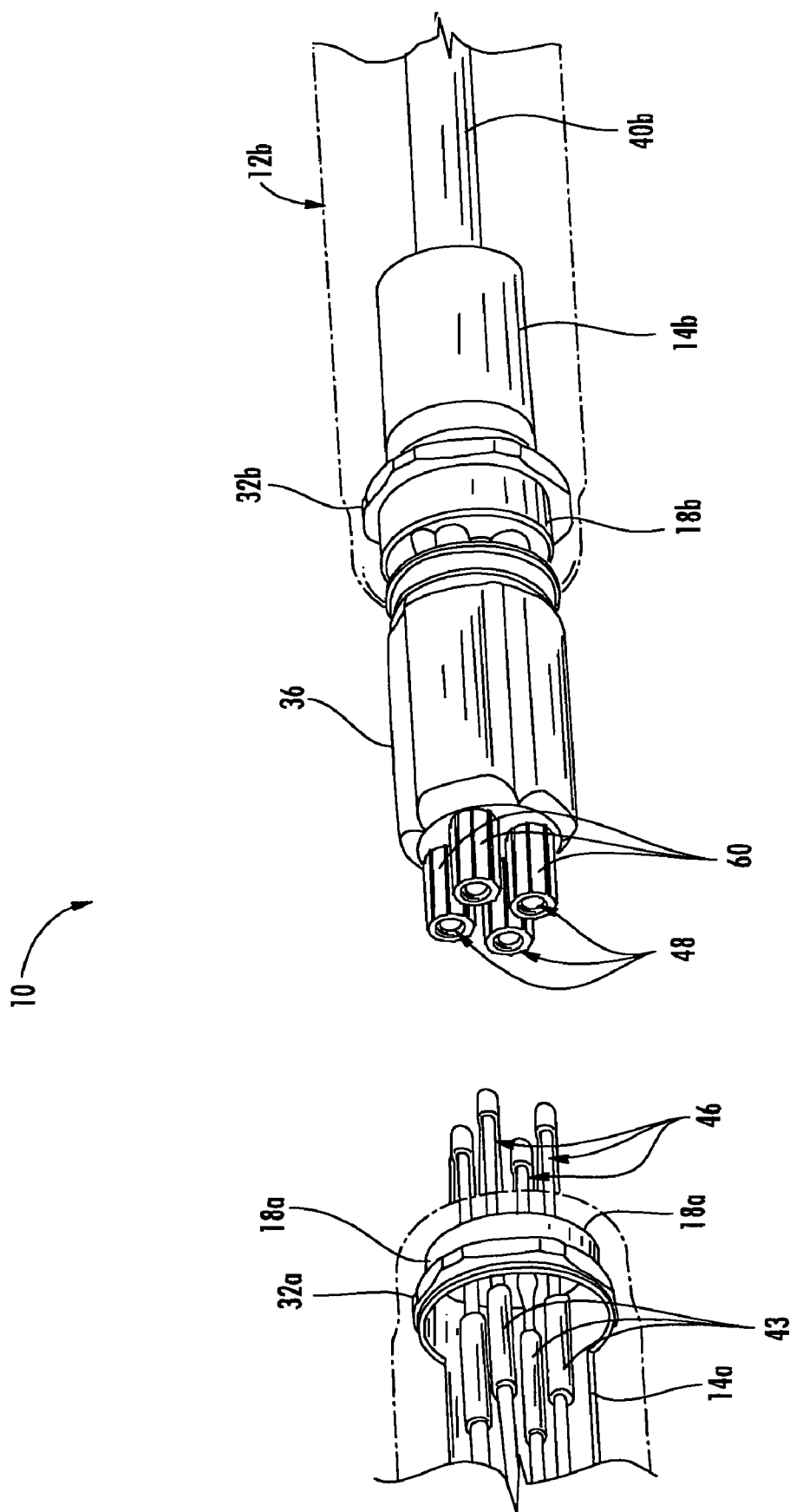


FIG. 13

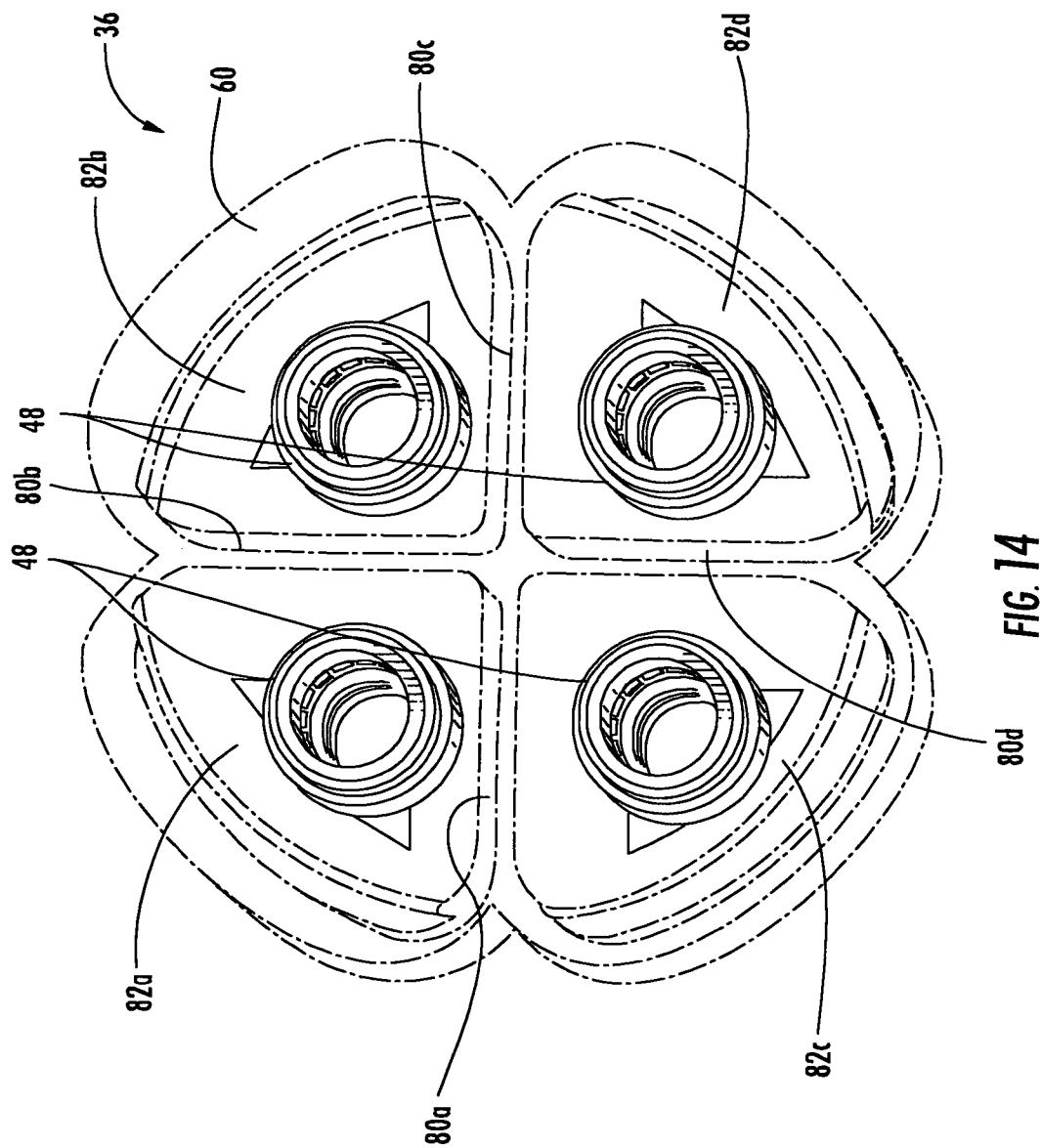


FIG. 14

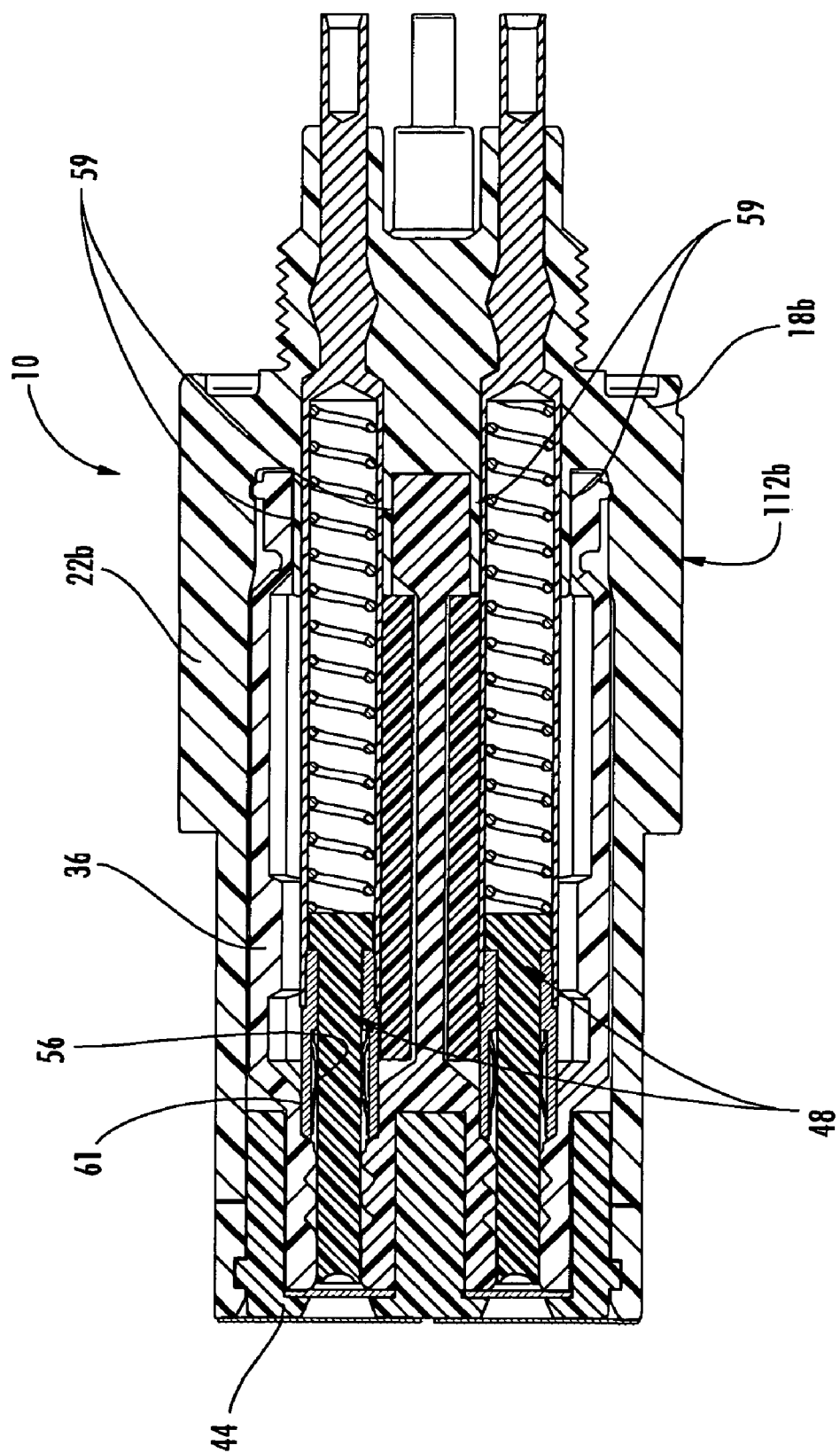


FIG. 15

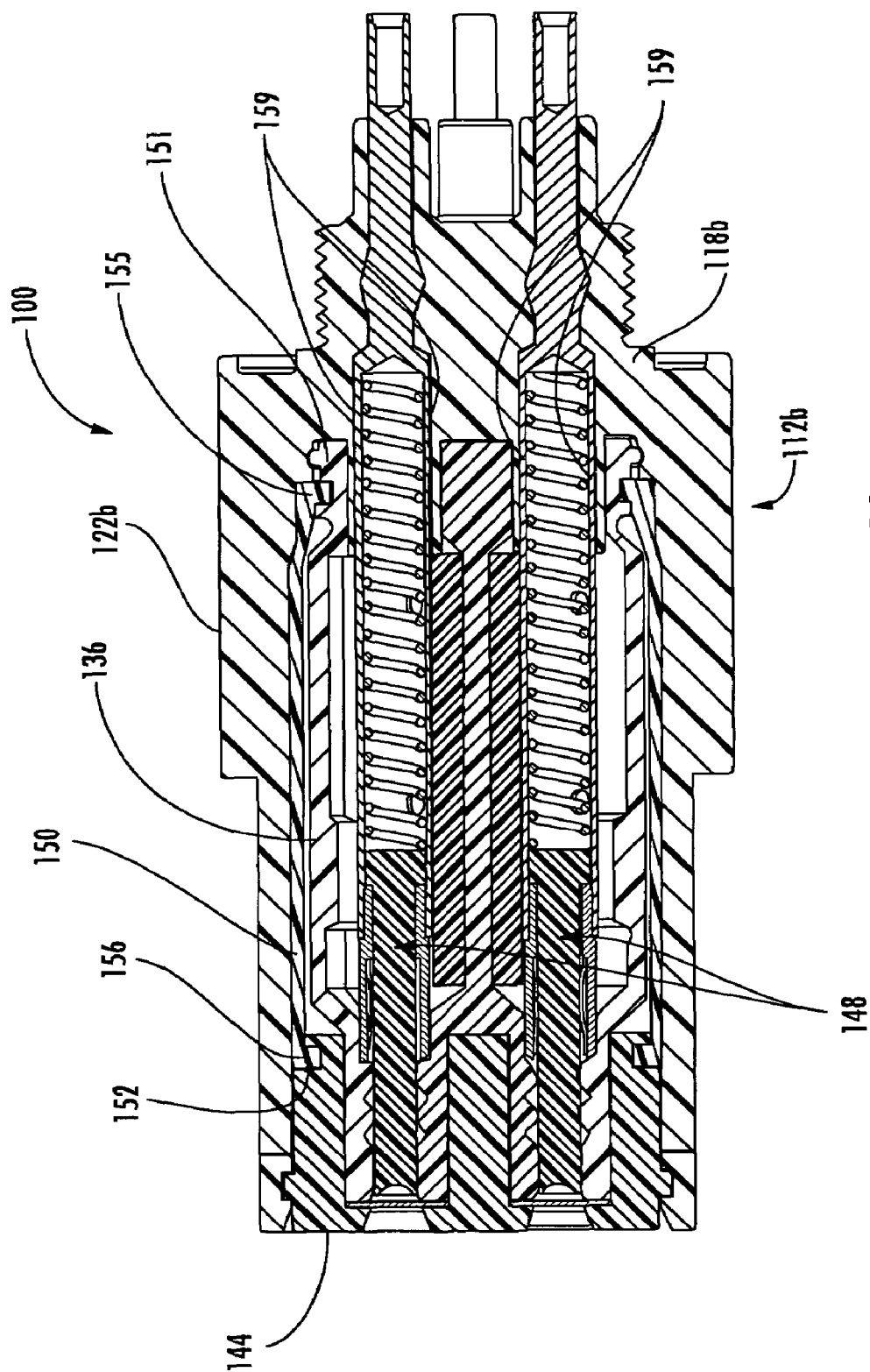
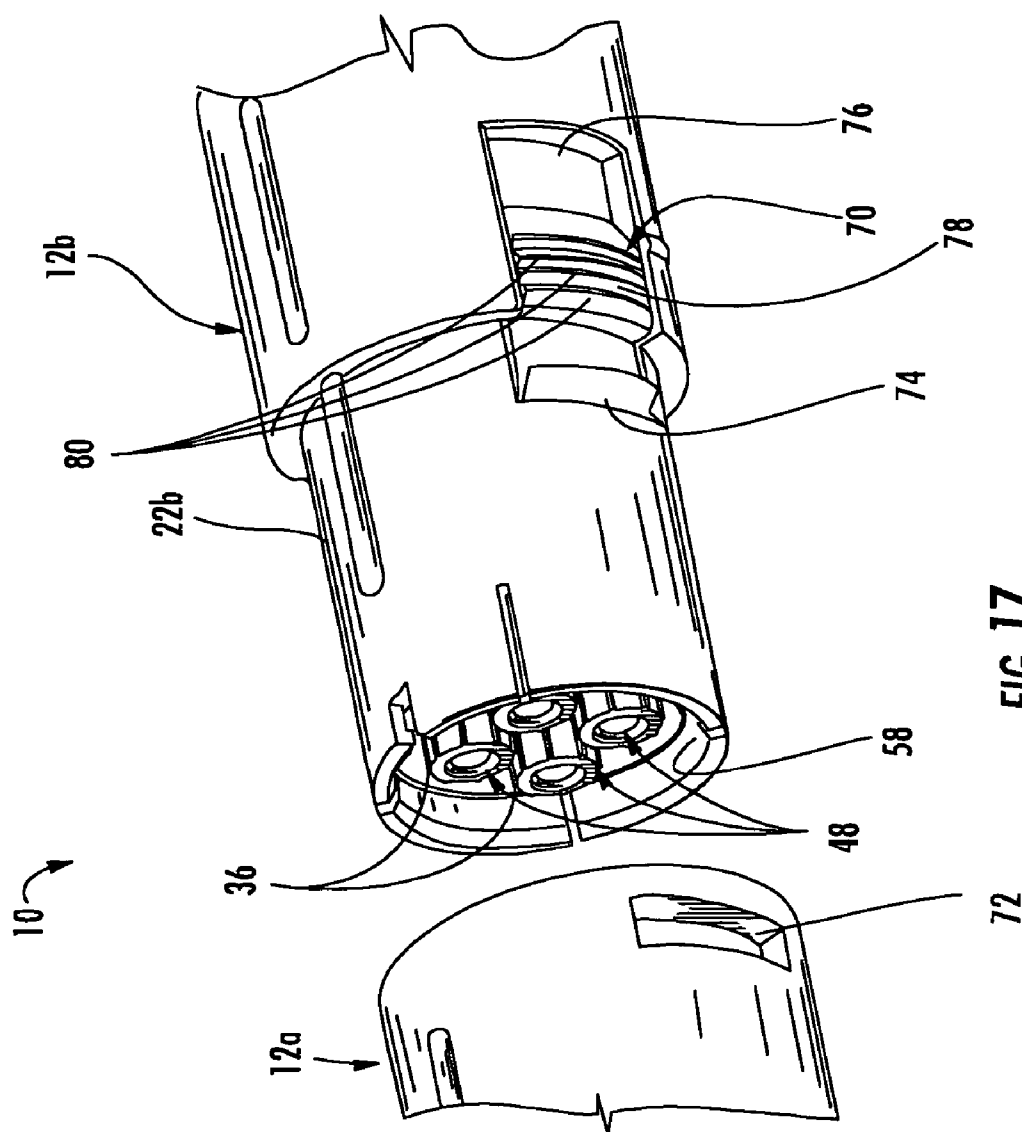


FIG. 16





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# **HARSH ENVIRONMENT CONNECTOR INCLUDING END CAP AND LATCHING FEATURES AND ASSOCIATED METHODS**

## **FIELD OF THE INVENTION**

The invention relates to the field of cable connectors, and, more particularly, to cable connectors and related methods such as for harsh environments.

## **BACKGROUND OF THE INVENTION**

Underwater cables are commonly used to carry electrical power and/or telecommunications traffic. There is also typically a need to make connections between adjacent cable ends, or between a cable end and associated equipment, for example. Accordingly, there are also cable connectors for such harsh or underwater, high pressure environments. Such cable connectors not only have to operate under extreme conditions, but for some applications they may need to be mateable while submerged, that is, wet-mateable. A submersible robotic device may also typically be used to mate the wet-mateable cable connector portions, and such a robotic device may be limited in the types of movements and forces it is capable of generating.

The assignee of the present invention, Ocean Design, Inc. of Ormond Beach, Fla., has developed various significant improvements in wet-mateable connectors as disclosed in U.S. Pat. Nos. 4,948,377; 5,162,617; 5,194,012; 5,203,805; 5,645,438; 5,645,442; 5,772,457; 5,722,842; 5,873,750; 6,017,227; 6,067,395; 6,315,461; 6,332,787; 6,464,405; 6,736,545; 6,796,821; and 6,910,910, for example. The entire content of each of these patents is incorporated herein by reference.

U.S. Pat. No. 6,315,461, for example, discloses a wet-mateable connector comprising first and second connector portions being movable between unmated and mated positions. In addition, the connector also includes first and second tubular bladders in respective connector portions and cooperating therewith so that opposing ends of the tubular bladders are urged together and moved from a closed to an open position as the connector portions are moved from the unmated to the mated position. More particularly, the first connector portion includes a first tubular shell including interior portions defining a fixed oval constriction. The second connector portion comprises a second tubular shell and an actuator slidable therein and defining a slidable oval constriction. The second tubular bladder is extended longitudinally beyond the slidable and fixed oval constrictions and into the interior of the first shell when the connector portions are moved to the mated position. Accordingly, the bladders are in the open position, yet providing a seal therebetween to surrounding water, to permit engagement of contacts when mated. Conversely, the bladders are closed to seal the respective contacts from the surrounding water when in the unmated position. Commercial versions of this wet-mateable connector are offered from Ocean Design, Inc. of Ormond Beach, Fla. under the designation I-CONN™.

Another line of wet-mateable connectors is also offered by Ocean Design, Inc. of Ormond Beach, Fla. under the designation Nautilus™. For example, U.S. Pat. No. 5,203,805 discloses features of this connector. The Nautilus™ connector includes first and second connector portions movable between unmated and mated positions. The first connector portion comprises a first base, male contacts carried by the first base and extending outwardly therefrom, and a first shell carried by the first base and surrounding the male

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contacts. The second connector portion comprises a second base, and female contacts carried by the second base and extending outwardly therefrom. Individual bladders surround each female contact, and an overall bladder surrounds all of the individual bladders. This provides two bladder chambers surrounding each female contact. A second shell is carried by the second base and surrounds the bladders. The Nautilus™ connector also includes an end cap that is carried by a pair of oppositely positioned stalks that extend outwardly from the base. Moreover, the end cap includes several component parts to be manufactured and assembled.

Despite continuing developments in harsh environment connector technology, it may still be desirable to reduce part counts/simplify manufacturing for such connectors and while maintaining a high degree of reliability.

## **SUMMARY OF THE INVENTION**

In view of the foregoing background, it is therefore an object of the invention to provide a connector that is more readily manufactured and still reliable in service.

This and other objects, features, and advantages in accordance with the invention are provided by a connector including first and second connector portions being movable between unmated and mated positions, and wherein the end cap serves to retain and align end portions of a bladder. More particularly, the first connector portion may include a first base, at least one male contact carried by the first base and extending outwardly therefrom, and a first shell carried by the first base and surrounding the male contact. The second connector portion may include a second base, at least one female contact carried by the second base and extending outwardly therefrom, and a bladder carried by the second base and surrounding the at least one female contact. The second connector portion may further include the end cap having at least one passageway therein for retaining and aligning end portions of the bladder opposite the second base, and the second shell carried by the second base and surrounding the bladder and the end cap.

The end cap and adjacent portions of the second shell may comprise respective mating portions to provide a snap fit engagement therebetween. For example, the end cap may comprise an enlarged diameter flange and the second shell may have a recess for receiving the enlarged diameter flange therein. The snap fit engagement may provide for more efficient assembly during manufacturing.

In accordance with another advantageous feature, the end cap may comprise a monolithic body, such as an integrally molded monolithic body. For example, the integrally molded monolithic body may have a disk shape.

The female contact may comprise a guide tube, a moveable stopper received in an end of the guide tube, and a spring urging the stopper toward the end of the guide tube. The female contact may further comprise a contact band received in the end of the guide tube. The male contact may comprise an electrically conductive member and a dielectric layer surrounding a portion thereof to define an electrically conductive tip.

A method aspect is directed to making a connector that may comprise first and second connector portions being movable between unmated and mated positions. The method may comprise forming the first connector portion to include a first base, a male contact carried by the first base and extending outwardly therefrom, and a first shell carried by the first base and surrounding the male contact. The method may also comprise forming the second connector portion to include a second base, a female contact carried by the

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second base and extending outwardly therefrom, a bladder carried by the second base and surrounding the female contact, an end cap having at least one passageway therein retaining and aligning end portions of the bladder opposite the second base, and a second shell carried by the second base and surrounding the bladder and the end cap. The method may further comprise, when forming the second connector portion, forming the end cap and the adjacent portions of the second shell to include respective mating portions to provide a snap fit engagement therebetween. The end cap may be an integrally formed monolithic body, such as having a disk shape.

Another aspect relates to latching of the first and second connector portions together. For example, the connector may include first and second connector portions being movable between unmated and mated positions, wherein one of the first and second shells includes a manual release latch and the other has a corresponding latch opening therein. The manual release latch may include a fixed end, a cantilevered catch end and a medial release portion therebetween. The cantilevered catch end may disengage the corresponding latch opening upon depression of the medial release portion. The medial release portion may extend radially outwardly beyond the fixed end and the cantilevered catch end. The medial release portion may have a series of grooves therein. For a typical connector, the manual release latch may comprise a pair of manual release latches on opposing sides of its shell. Similarly, the latch opening may comprise a pair of latch openings on opposing sides of its shell.

A related method aspect is directed to making the connector and may include forming the first connector portion to include a first base, at least one male contact carried by the first base and extending outwardly therefrom, and a first shell carried by the first base and surrounding the at least one male contact. The method may also comprise forming the second connector portion to include a second base, at least one female contact carried by the second base and extending outwardly therefrom, a bladder carried by the second base and surrounding the at least one female contact, an end cap surrounding the bladder at end portions thereof opposite the second base, and a second shell carried by the second base and surrounding the bladder and the end cap. The method may further comprise forming one of the first and second shells to include at least one manual release latch and the other shell to have at least one corresponding latch opening therein. The method may also comprise forming the at least one manual release latch to include a fixed end, a cantilevered catch end and a medial release portion therebetween, the cantilevered catch end disengaging the corresponding latch opening upon depression of the medial release portion.

### BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a side perspective view of the cable connector in accordance with the invention shown in the unmated position.

FIG. 2 is a reverse side perspective view of the cable connector of FIG. 1.

FIG. 3 is a side perspective view of the cable connector of FIG. 1 in the mated position.

FIG. 4 is a side elevational view, partially in section, of the cable connector as shown in FIG. 3.

FIG. 5 is an enlarged side elevational view, partially in section, of the cable connector of FIG. 1 with the elastomeric outer seal removed for clarity of explanation.

FIG. 6 is an enlarged cross-sectional view of the elastomeric inner seal as shown in the cable connector of FIG. 5.

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FIG. 7 is a side elevational view, partially in section, of a connector portion for a hybrid cable including an electrical and an optical cable member in accordance with an alternative embodiment of the invention.

FIG. 8 is a greatly enlarged side perspective view of the mating portions of the cable connector of FIG. 1 illustrating the end cap.

FIG. 9 is a side perspective view of the cable connector as shown in FIG. 8 with the second shell removed for clarity of explanation.

FIG. 10 is a side perspective view of the cable connector as shown in FIG. 8 with the end cap removed for clarity of explanation.

FIG. 11 is a side perspective view, partially in section, of the cable connector of FIG. 1 with some of the components removed for clarity of explanation.

FIG. 12 is another side perspective view, partially in section, of the cable connector of FIG. 1 with others of the components removed for clarity of explanation.

FIG. 13 is another side perspective view, partially in section, of the cable connector of FIG. 1 with others of the components removed for clarity of explanation.

FIG. 14 is an enlarged transverse cross-sectional view of the single-level bladder of the connector of FIG. 1.

FIG. 15 is a longitudinal cross-sectional view of the single-level bladder and connector portion as shown in FIG. 1.

FIG. 16 is a longitudinal cross-sectional view of another embodiment of a connector portion in accordance with the invention and including a dual-level bladder.

FIG. 17 is an enlarged side perspective view, partially in section, of the mating portions of the cable connector of FIG. 1.

### DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

The invention will now be described more fully hereinafter with reference to the accompanying drawings, in which preferred embodiments of the invention are shown. This invention may, however, be embodied in many different forms and should not be construed as limited to the embodiments set forth herein. Rather, these embodiments are provided so that this disclosure will be thorough and complete, and will fully convey the scope of the invention to those skilled in the art. Like numbers refer to like elements throughout.

Referring initially to FIGS. 1-6, a connector 10 and its sealing apparatus for harsh environments in accordance with the invention is now described. The connector 10 illustratively comprises first and second connector portions 12a, 12b being movable between unmated and mated positions as will be appreciated by those of skill in the art. Each connector portion 12a, 12b includes an elastomeric inner seal 14a, 14b and an elastomeric outer seal 16a, 16b surrounding the inner seal. More particularly, each connector portion 12a, 12b illustratively includes a base 18a, 18b, a plurality of electrical contacts 20a, 20b carried by the base and extending rearwardly therefrom, and a shell 22a, 22b carried by the base and extending forwardly therefrom. Each base 18a, 18b also includes a plurality of dielectric nipples 30a, 30b through which the respective electrical contacts 20a, 20b extend. Each elastomeric inner seal 14a, 14b is positioned adjacent the respective base 18a, 18b on a rear side thereof.

With particular reference to FIGS. 5 and 6, the elastomeric inner seal 14a has nipple passageways 29a for receiv-

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ing respective nipples **30a** therein, and has cable member passageways **24a**, **24b** for receiving the respective cable members therein. The cable member passageways **24a** are in communication with the nipple passageways **29a**. Intermediate diameter passageways **27a** may be optionally provided to accommodate the electrical contacts **20a** that may have a diameter between those of the cable member and nipple. In other embodiments, the cable member passageways **24a** may simply stretch to accommodate the contacts **20a** as will be appreciated by those skilled in the art.

Each elastomeric outer seal **16a**, **16b** is carried by the base **18a**, **18b**, and has a cable-end passageway **26a**, **26b** therein. In addition, each elastomeric outer seal **16a**, **16b** may also have an inner seal passageway **28a**, **28b** therein aligned with the cable-end passageway **26a**, **26b** for receiving the elastomeric inner seal **14a**, **14b**. The combination of the elastomeric inner seal **14a**, **14b** and the elastomeric outer seal **16a**, **16b** provide an effective seal, such as against water ingress, and may also be readily assembled onto a cable end in the field, if desired.

The nipple passageways **29a** may define a constrictive seal with the nipples **30a** that is devoid of adhesive. The cable member passageways **24a**, **24b** and the cable members **20a**, **20b** may also define constrictive seals therebetween also devoid of adhesive as will be appreciated by those of skill in the art to thereby facilitate field assembly and disassembly. Similarly, the inner seal passageway **28a**, **28b** and the elastomeric inner seal **14a**, **14b** may define a constrictive seal therebetween, such as also devoid of adhesive.

Each base **18a**, **18b** includes a sealing flange **32a**, **32b**, and the elastomeric outer seal **16a**, **16b** may have a flange receiving recess **37a**, **37b** therein to define a constrictive seal with the sealing flange. As noted above, this seal may also be devoid of adhesive to facilitate field assembly and disassembly.

In some embodiments as few as one pair of contacts may be used as will be appreciated by those skilled in the art. In the illustrated embodiment, the contacts **20a**, **20b** and associated nipples **30a**, **30b** comprise a plurality carried by the base **18a**, **18b** in spaced apart relation. In these embodiments, the nipple passageways **29a**, **29b** include a plurality thereof corresponding to the plurality of contacts **20a**, **20b**. In addition, the cable member passageways **24a**, **24b** include a corresponding plurality thereof and these are arranged to diverge outwardly in a direction toward the base **18a**, **18b** or, considered in other terms, toward a first open end of the elastomeric outer seal **16a**, **16b** that is adjacent the base.

Each cable-end passageway **26a**, **26b** also illustratively has an enlarged diameter end portion **38a**, **38b** and a reduced diameter intermediate portion **40a**, **40b**. The enlarged diameter end portion **38a**, **38b** may constrictively seal against the jacket of the cable, while the intermediate reduced diameter portion **40a**, **40b** retains the inner members, for example, individual insulated wires, of the cable with the overall jacket stripped back therefrom. This stepped configuration reduces unnecessary voids within the elastomeric outer seal **16a**, **16b** when a cable is inserted therein thereby reducing deformation of the elastomeric outer seal under pressure. In addition, each elastomeric outer seal **16a**, **16b** may have a tapered outer shape **34a**, **34b** adjacent a cable-receiving end **42a**, **42b** thereof to provide greater flexibility adjacent the end.

Each elastomeric outer seal **16a**, **16b** and elastomeric inner seal **14a**, **14b** may comprise an elastomeric material, such as natural rubber, for example, although other similar synthetic elastomeric materials may also be used as will be

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appreciated by those skilled in the art. As will also be appreciated by those skilled in the art, the sealing apparatus comprising the elastomeric inner and outer seals may be used with only a single connector portion in other embodiments. In other words, the sealing apparatus may be used between a cable end and any cable termination, such as the illustrated connector portion, or for a bulkhead connector etc. as will be appreciated by those skilled in the art. The sealing apparatus as described herein is readily assembled and/or disassembled in the field thereby overcoming the disadvantages of the prior art sealing arrangements, such as those requiring heat shrink materials or potted polyurethane, for example.

Referring now briefly to FIG. 7, another embodiment of a connector portion or cable termination **12a'** including the sealing apparatus is now described that is used in combination with a hybrid fiber optic and electrical cable **39a'**. For simplicity of explanation the hybrid cable **39a'** illustratively includes a single electrical cable member **41a'** and a single optical fiber cable member **49a'** extending from the protective jacket as shown in the illustrated embodiment. Of interest, the optical fiber cable member **49a'** extends through a passageway in the upper nipple **30a'**. In contrast, the electrical cable member **41a'** may be soldered to the contact **20a'** carried by the lower nipple **30a'**. As will be appreciated by those skilled in the art, the sealing apparatus provided by the illustrated elastomeric inner and outer seals **14a'**, **16a'** may be used for many cable types including an all-fiber optic cable, for example. As will also be understood by those skilled in the art, the intermediate passageway **40a'** surrounding the optical cable member **49a'** and electrical cable member **41a'** is likely to be much more closely fitting than shown in the drawing figure which is exaggerated for ease of explanation.

Referring now additionally to FIGS. 8-10, other features and advantages relating to the end cap **44** of the connector **10** are now described. A bladder **36** is carried by the second base **18b** and surrounds the female contacts **48**. The second connector portion **12b** further includes the integrally molded, disk-shaped, monolithic end cap **44** that surrounds the bladder **36** at end portions thereof opposite the second base **18b**. The second connector portion **12b** also includes a second shell **22b** carried by the second base **18b** and surrounding the bladder **36** and the end cap **44**.

The connector **10** may further comprise a dielectric, such as a silicone oil, contained within the bladder **36** as will be appreciated by those of skill in the art. The end cap **44** has a series of passageways **64** therein to surround the end portions of the bladder **36**. More particularly, the end cap **44** may serve to retain and align the end portions of the bladder **36**.

The integrally molded, disk-shaped, monolithic end cap **44** is in contrast to the multi-piece end cap assemblies, such as in prior art connectors. The end cap **44** may be readily manufactured using conventional plastic molding techniques, for example, as will be appreciated by those skilled in the art.

The end cap **44** is illustratively carried by adjacent portions of the second shell **22b**. The end cap **44** and the adjacent portions of the second shell **22b** may comprise respective mating portions to provide a snap fit engagement therebetween, for example, to facilitate assembly. The end cap **44** illustratively comprises an enlarged diameter flange **66**, and the second shell **22b** comprises a recess **68** for receiving the enlarged diameter flange therein in a snap fit engagement. The second shell **22b** also includes a series of

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circumferentially spaced slits **62** to provide resiliency for the snap fit engagement as will be appreciated by those skilled in the art.

A key alignment feature is also provided in the form of the tab **63b** carried by the end cap **44** and a corresponding slot **63a** formed in the second shell **22b**. Of course, those skilled in the art will appreciate that other respective mating portions may be provided on the end cap **44** and second shell **22b** to provide the snap fit engagement.

Referring now additionally to FIGS. **11-12**, the female contact **48** illustratively comprises a guide tube **50**, a moveable stopper **52** received in an end of the guide tube, and a spring **54** urging the stopper toward the end of the guide tube. The female contact **48** also illustratively includes a band-seat **61**. The band-seat **61** may surround a contact band, not shown in FIGS. **11-12**, but perhaps best shown and identified as contact band **56** in FIG. **15**.

The male contact **46** may comprise a dielectric tube **43**, and an electrically conductive member **45** extending there-through and terminating beyond an end thereof to define an electrically conductive tip **47** as will be appreciated by those of skill in the art. In other words, the electrically conductive member **45** may include a dielectric layer **43** surrounding a portion thereof to define an electrically conductive tip.

Referring now additionally to FIGS. **13-15**, other features and advantages of the connector **10** as related to the bladder **36** are now described. The second connector portion **12b** further comprises the bladder **36** carried by the base **18b**. Moreover, the bladder **36** is illustratively a single-level bladder. By single-level is meant that only a single dielectric retaining chamber is defined around each female contact **48**. The single-level bladder **36** comprises an outer wall **60** and at least one wall partition **80a-80d** therein defining a respective single-level bladder chamber **82a-82d** for each of the female contacts **48**, for example. The outer wall **60** and the at least one wall partition **80a-80d** may be integrally formed as a monolithic unit. The end cap **44** surrounds the single-level bladder **36** at end portions thereof opposite the second base **18b**. This single-level bladder **36** is less complex than prior art multi-level bladders, yet still provides reliable sealing as will be appreciated by those skilled in the art. The structure of the end cap **44** in cooperation with the end seal portions of the bladder **36**, provides improved positioning and sealing over the previous end-seal constructions of the Nautilus connectors as well as those manufactured by Tronic of Cumbria, United Kingdom. It also obviates the need for redundant end-seals, such as incorporated into Tronic's outer bladder as will be appreciated by those skilled in the art.

Another aspect of the connector **10** is that the ends of the bladder **36** adjacent the base **18b** may also form effective constrictive seals with adjacent portions of the inwardly extending nipples **59** as perhaps best understood with reference to FIG. **15**. The inwardly extending nipples **59** are aligned with the respective female contacts **48** as will be appreciated by those skilled in the art.

The prior art Nautilus outer bladder was added to enclose a benign outer environment for the inner bladders in case of flaws in the inner bladder walls. The wall thickness, and hence durability of the Nautilus inner bladders may be difficult to verify, rendering them potentially fragile. The present monolithic multi-chambered, single-level bladder **36** reduces the chambers' area exposed to the outer environment by much more than half compared to previous constructions. One reduction comes from the shared inner partitions. The other reduction comes from the foreshortening offered by the internal nipples **59**. The multi-chambered

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monolithic, single-level bladder **36** may be correspondingly more reliable than those of either the Tronic or Nautilus prior art connectors, and therefore may not have the same need for protection. The internal partitions serve to keep the chambers of the bladder **36** axially aligned, and reduce the tendency squirm out of position present in other constructions as will be appreciated by those skilled in the art.

Referring now additionally to FIG. **16** another aspect of the invention relates to dual-level bladder connector **100**. The connector **100** may include first and second connector portions movable between unmated and mated positions as described above. As also described above, the first connector portion may comprise a first base, at least one male contact carried by the first base and extending outwardly therefrom, and a first shell carried by the first base and surrounding the at least one male contact. The second connector portion **112b** is illustrated in FIG. **16** and includes a second base **118b**, a plurality of female contacts **148** carried by the second base and extending outwardly therefrom, an inner bladder **136** carried by the second base surrounding the female contacts, and an end cap **144** defining a seal to end portions of the inner bladder opposite the second base.

The second connector portion **112b** also illustratively includes an outer bladder **150** surrounding the inner bladder **136**, and a second shell **122b** carried by the second base **118b** and surrounding the outer bladder and the end cap **144**. The outer bladder **150** defines a first seal with the inner bladder **136** adjacent the base **118b** and defines a second seal with the end cap **144**. The inner bladder **136** illustratively has a first recess **151** on an outer surface thereof, and the outer bladder **150** comprises a first inwardly extending flange **155** received in the first recess to define the first seal. Similarly, the end cap **144** illustratively has a second recess **152** on an outer surface thereof, and the outer bladder **150** comprises a second inwardly extending flange **156** received in the second recess to define the second seal.

The second shell **122b** also illustratively comprises respective inner surface portions urging the first and second inwardly extending flanges into the respective first and second recesses. The outer bladder **150** creates a second oil chamber around the inner bladder **136** and the inner bladder ends are sealed into the end cap **144** to contain the outer oil volume. The distal ends of the outer bladder **150** are locked and captured into the end cap **144** and adjacent portions of the shell **122b**, and the proximal ends of the outer bladder are locked and sealed into the inner bladder **136** and adjacent portions of the shell.

Another aspect of the connector **100** is that the ends of the inner bladder **136** adjacent the base **118b** may also form effective constrictive seals with adjacent portions of the inwardly extending nipples **159**. The inwardly extending nipples **159** are aligned with the respective female contacts **148** as will be appreciated by those skilled in the art.

Now with additional reference to FIG. **17**, a manual release latching configuration is described for the first and second shells **22a**, **22b**. In the illustrated embodiment, the second shell **22b** includes a manual release latch **70** and the first shell **22a** has a corresponding latch opening **72** therein. The manual release latch **70** illustratively includes a fixed end **76**, a cantilevered catch end **74** and a medial release portion **78** therebetween, for example. The cantilevered catch end **74** disengages the corresponding latch opening **72** upon depression of the medial release portion **78** as will be appreciated by those of skill in the art.

The medial release portion **78** may extend radially outwardly beyond the fixed end **76** and the cantilevered catch end **74** as shown in the illustrated embodiment. In addition,

the medial release portion 78 has a series of grooves 80 therein to facilitate manipulation.

Although only a single latch and latch opening are visible in FIG. 17, the connector would typically include a pair of manual release latches and latch openings on opposing sides of one of the first and second shells 22a, 22b. The first and second shells 22a, 22b each may comprise an integrally molded tubular plastic body into which the latching features may be readily formed as will be appreciated by those skilled in the art.

One method aspect is for sealing a cable end and a cable termination. The cable end may include a cable jacket and at least one cable member extending outwardly therefrom. The cable termination may comprise a base and at least one nipple extending outwardly therefrom. The method may include positioning an elastomeric inner seal having at least one nipple passageway to receive and define a seal with the at least one nipple, and at least one cable member passageway in communication with the at least one nipple passageway to receive and define a seal with the at least one cable member. The method may also include positioning an elastomeric outer seal having opposing first and second open ends, the first open end to engage and define a seal with the base; an elastomeric inner seal passageway to receive the elastomeric inner seal; and a cable end passageway extending in communication with the elastomeric inner seal passageway to the second open end to receive and define a seal with the cable jacket.

Another method aspect is directed to making a connector that may comprise first and second connector portions being movable between unmated and mated positions. The method may comprise forming the first connector portion to include a first base, a male contact carried by the first base and extending outwardly therefrom, and a first shell carried by the first base and surrounding the male contact. The method may also comprise forming the second connector portion to include a second base, a female contact carried by the second base and extending outwardly therefrom, a bladder carried by the second base and surrounding the female contact, an end cap to retain and align end portions of the bladder opposite the second base, and a second shell carried by the second base and surrounding the bladder and the end cap. The method may further comprise, when forming the second connector portion, forming the end cap and the adjacent portions of the second shell to include respective mating portions to provide a snap fit engagement therebetween. The end cap may be an integrally formed monolithic body, such as having a disk shape.

Still another related method aspect is directed to making a connector and may include forming the first connector portion to include a first base, at least one male contact carried by the first base and extending outwardly therefrom, and a first shell carried by the first base and surrounding the at least one male contact. The method may also comprise forming the second connector portion to include a second base, at least one female contact carried by the second base and extending outwardly therefrom, a bladder carried by the second base and surrounding the at least one female contact, an end cap surrounding the bladder at end portions thereof opposite the second base, and a second shell carried by the second base and surrounding the bladder and the end cap. The method may further comprise forming one of the first and second shells to include at least one manual release latch and the other shell to have at least one corresponding latch opening therein. The method may also comprise forming the at least one manual release latch to include a fixed end, a cantilevered catch end and a medial release portion therebetween,

the cantilevered catch end disengaging the corresponding latch opening upon depression of the medial release portion.

A further method aspect is also directed to making a connector comprising first and second connector portions to be movable between unmated and mated positions. The method may comprise forming the first connector portion to include a first base, at least one male contact carried by the first base and extending outwardly therefrom, and a first shell carried by the first base and surrounding the at least one male contact. The method further comprises forming the second connector portion to include a second base, at least one female contact carried by the second base and extending outwardly therefrom, a single-level bladder carried by the second base and defining only a single-level bladder chamber surrounding the at least one female contact, and a second shell carried by the second base and surrounding the single-level bladder.

Still another aspect relates to making the dual-level bladder connector embodiments. The method may include forming first connector portion to comprise a first base, at least one male contact carried by the first base and extending outwardly therefrom, and a first shell carried by the first base and surrounding the at least one male contact. The method may also include forming the second connector portion to comprise a second base, at least one female contact carried by the second base and extending outwardly therefrom, an inner bladder carried by the second base surrounding the at least one female contact, an end cap defining a seal to end portions of the inner bladder opposite the second base, an outer bladder surrounding the inner bladder, and a second shell carried by the second base and surrounding the outer bladder and the end cap. Moreover, the outer bladder may define a first seal with the inner bladder adjacent the base and defining a second seal with the end cap.

Other features and advantages of the connector, sealing apparatus, various components and related methods are disclosed in copending patent application Ser. No. 11/323,150, titled HARSH ENVIRONMENT CONNECTOR INCLUDING SINGLE-LEVEL OR DUAL-LEVEL BLADDER AND ASSOCIATED METHODS and Ser. No. 11/322,698, titled HARSH ENVIRONMENT SEALING APPARATUS FOR A CABLE END AND CABLE TERMINATION AND ASSOCIATED METHODS both incorporated herein by reference. Accordingly, many modifications and other embodiments of the invention will come to the mind of one skilled in the art having the benefit of the teachings presented in the foregoing descriptions and the associated drawings. Therefore, it is understood that the invention is not to be limited to the specific embodiments disclosed, and that other modifications and embodiments are intended to be included within the scope of the appended claims.

The invention claimed is:

1. A connector comprising:

first and second connector portions movable between unmated and mated positions;

said first connector portion comprising a first base, at least one male contact carried by said first base and extending outwardly therefrom, and a first shell carried by said first base and surrounding said at least one male contact;

said second connector portion comprising a second base, at least one female contact carried by said second base and extending outwardly therefrom, a bladder carried by said second base and surrounding said at least one female contact, an end cap having at least one passage-

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way therein for retaining and aligning end portions of said bladder opposite said second base, and a second shell carried by said second base and surrounding said bladder and said end cap, the second shell being secured to said end cap.

**2. A connector comprising:**

first and second connector portions movable between unmated and mated positions;

said first connector portion comprising a first base, at least one male contact carried by said first base and extending outwardly therefrom, and a first shell carried by said first base and surrounding said at least one male contact;

said second connector portion comprising a second base, at least one female contact carried by said second base and extending outwardly therefrom, a bladder carried by said second base and surrounding said at least one female contact, an end cap having at least one passageway therein for retaining and aligning end portions of said bladder opposite said second base, and a second shell carried by said second base and surrounding said bladder and said end cap;

said end cap and adjacent portions of said second shell comprising respective mating portions to provide a snap fit engagement therebetween.

**3. The connector according to claim 2 wherein said end cap comprises an enlarged diameter flange; and wherein said second shell has a recess for receiving said enlarged diameter flange therein.**

**4. The connector according to claim 1 wherein said end cap comprises an integrally formed monolithic body.**

**5. The connector according to claim 4 wherein said integrally formed monolithic body has a disk shape.**

**6. The connector according to claim 1 wherein said at least one female contact comprises a guide tube, a moveable stopper received in an end of said guide tube, and a spring urging said stopper toward the end of said guide tube.**

**7. The connector according to claim 6 wherein said at least one female contact further comprises a contact band received in the end of said guide tube.**

**8. The connector according to claim 1 wherein said at least one male contact comprises a plurality of male contacts; and wherein said at least one female contact comprises a plurality of female contacts corresponding to said plurality of male contacts.**

**9. The connector according to claim 1 further comprising a dielectric material within said bladder.**

**10. The connector according to claim 1 wherein said at least one male contact comprises an electrically conductive member and a dielectric layer surrounding a portion thereof to define an electrically conductive tip.**

**11. A connector comprising:**

first and second connector portions movable between unmated and mated positions;

said first connector portion comprising a first base, a plurality of male contacts carried by said first base and extending outwardly therefrom, and a first shell carried by said first base and surrounding said male contacts;

said second connector portion comprising a second base, a plurality of female contacts carried by said second base and extending outwardly therefrom, a bladder carried by said second base and surrounding said female contacts, a monolithic end cap having a plurality of passageways therein for retaining and aligning end portions of said bladder opposite said second base, and a second shell carried by said second base and surrounding said bladder and said monolithic end cap;

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said monolithic end cap having an enlarged diameter flange and said second shell having a recess therein mating with said enlarged diameter flange to provide a snap fit engagement therebetween.

**12. The connector according to claim 11 wherein said monolithic end cap comprises an integrally formed monolithic body having a disk shape.**

**13. The connector according to claim 11 wherein said female contacts each comprises a guide tube, a moveable stopper received in an end of said guide tube, and a spring urging said stopper toward the end of said guide tube.**

**14. The connector according to claim 11 further comprising a dielectric material within said bladder.**

**15. The connector according to claim 11 wherein said male contacts each comprises an electrically conductive member and a dielectric layer surrounding a portion thereof to define an electrically conductive tip.**

**16. A method for making a connector comprising first and second connector portions to be movable between unmated and mated positions, the method comprising:**

forming the first connector portion to comprise a first base, at least one male contact carried by the first base and extending outwardly therefrom, and a first shell carried by the first base and surrounding the at least one male contact;

forming the second connector portion to comprise a second base, at least one female contact carried by the second base and extending outwardly therefrom, a bladder carried by the second base and surrounding the at least one female contact, an end cap having at least one passageway therein for retaining and aligning end portions of the bladder opposite the second base, and a second shell carried by the second base and secured to the end cap, the second shell surrounding the bladder and the end cap.

**17. A method for making a connector comprising first and second connector portions to be movable between unmated and mated positions, the method comprising:**

forming the first connector portion to comprise a first base, at least one male contact carried by the first base and extending outwardly therefrom, and a first shell carried by the first base and surrounding the at least one male contact;

forming the second connector portion to comprise a second base, at least one female contact carried by the second base and extending outwardly therefrom, a bladder carried by the second base and surrounding the at least one female contact, an end cap having at least one passageway therein for retaining and aligning end portions of the bladder opposite the second base, and a second shell carried by the second base and surrounding the bladder and the end cap; and

the step of forming the second connector portion comprising forming the end cap and adjacent portions of the second shell to comprise respective mating portions to provide a snap fit engagement therebetween.

**18. The method according to claim 17 wherein the end cap comprises an enlarged diameter flange; and wherein the second shell comprises a recess for receiving the enlarged diameter flange therein.**

**19. The method according to claim 16 wherein the end cap comprises an integrally formed monolithic body.**

**20. The method according to claim 16 wherein the at least one female contact comprises a guide tube, a moveable stopper received in an end of the guide tube, and a spring urging the stopper toward the end of the guide tube.**

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21. The method according to claim 16 wherein the at least one male contact comprises a plurality of male contacts; and wherein the at least one female contact comprises a plurality of female contacts corresponding to the plurality of male contacts.

22. The method according to claim 16 further comprising filling the bladder with a dielectric material.

23. The method according to claim 16 wherein the at least one male contact comprises an electrically conductive member and a dielectric layer surrounding a portion thereof to define an electrically conductive tip.

24. A connector comprising:

first and second connector portions movable between unmated and mated positions;

said first connector portion comprising a first base, at least one male contact carried by said first base and extending outwardly therefrom, and a first shell carried by said first base and surrounding said at least one male contact;

said second connector portion comprising a second base, at least one female contact carried by said second base and extending outwardly therefrom, a bladder carried by said second base and surrounding said at least one female contact, an end cap surrounding said bladder at end portions thereof opposite said second base, and a second shell carried by said second base and surrounding said bladder and said end cap;

the end cap and adjacent portions of said second shell comprising respective mating portions to provide a snap fit engagement therebetween;

one of said first and second shells comprising at least one manual release latch and the other of said first and second shells having at least one corresponding latch opening therein;

said at least one manual release latch comprising a fixed end, a cantilevered catch end and a medial release portion therebetween, said cantilevered catch end disengaging the corresponding latch opening upon depression of said medial release portion.

25. The connector according to claim 24 wherein said medial release portion extends radially outwardly beyond said fixed end and said cantilevered catch end.

26. The connector according to claim 24 wherein said medial release portion has a series of grooves therein.

27. The connector according to claim 24 wherein said at least one manual release latch comprises a pair of manual release latches on opposing sides of one of said first and second shells; and wherein the at least one latch opening comprises a pair of latch openings on opposing sides of the other of said first and second shells.

28. The connector according to claim 24 wherein said first and second shells each comprises an integrally molded tubular plastic body.

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29. The connector according to claim 24 wherein said at least one male contact comprises a plurality of male contacts; and wherein said at least one female contact comprises a plurality of female contacts corresponding to said plurality of male contacts.

30. The connector according to claim 24 further comprising a dielectric material within said bladder.

31. A method for making a connector comprising first and second connector portions to be movable between unmated and mated positions, the method comprising:

forming the first connector portion to comprise a first base, at least one male contact carried by the first base and extending outwardly therefrom, and a first shell carried by the first base and surrounding the at least one male contact;

forming the second connector portion to comprise a second base, at least one female contact carried by the second base and extending outwardly therefrom, a bladder carried by the second base and surrounding the at least one female contact, an end cap connected to the bladder at end portions thereof opposite the second base, and a second shell carried by the second base and surrounding the bladder and the end cap;

forming the end cap and adjacent portions of the second shell with respective mating portions to provide a snap fit engagement therebetween;

forming one of the first and second shells to comprise at least one manual release latch and the other of the first and second shells having at least one corresponding latch opening therein; and

forming the at least one manual release latch to comprise a fixed end, a cantilevered catch end and a medial release portion therebetween, the cantilevered catch end disengaging the corresponding latch opening upon depression of the medial release portion.

32. The method according to claim 31 wherein the medial release portion extends radially outwardly beyond the fixed end and the cantilevered catch end.

33. The method according to claim 31 wherein the medial release portion has a series of grooves therein.

34. The method according to claim 31 wherein the at least one manual release latch comprises a pair of manual release latches on opposing sides of one of the first and second shells; and wherein the at least one latch opening comprises a pair of latch openings on opposing sides of the other of said first and second shells.

35. The method according to claim 31 wherein the first and second shells each comprises an integrally molded tubular plastic body.

36. The method according to claim 31 further comprising filling the bladder with a dielectric material.

\* \* \* \* \*